

Work Order ID 61296

Friday, August 13, 2010 1:00:21 PM

Page 1

Item ID: D407-667-105

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Fwd

Start Date: 8/16/2010 Start Qty: 1.00

Required Date: 8/30/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-8-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D407-667-145

Rev C

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels as per PPP D407-667-105 CHG003

*8/10/09/13**Handwritten signature and date: 10-9-13*

110



Packaging

Packaging

Packaging

Memo

0.00

0.00

(IX) MB 10-08-30

120



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

0.00

Memo

0.00

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw

(IX) MB 10-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

8/10/08/30



Quality Control

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1- scribe batch # inside of cuff

2-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D407-667-145. Drill all (3) top holes use drill table jig DT8577 hole #1.#11 to set up towers, as per QSI0010.

3-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145 Check dimensions between holes on all four sides.

4-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

5-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg 407-667-145. Drill only the top (2) holes.

6-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D407-667-145.

7-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-145. Note: Fwd side has 3x top holes.

8-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D407-667-145.

9-C'sink holes as per Dwg D407-667-145. Allow rivet to sit below surface to compensate for paint.

10-Deburr & Inspect for surface damage. Repair damage within limits as per

10-8-30

10/08/30

10/08/31

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Dwg D407-667-145

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

(1X) 10-08-31

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 1005-01

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 1005-01

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Start Date: 8/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 Crosstubes	Crosstubes	0.00							
Crosstubes	Memo 1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up. A/R Magnobond 6398 : 114158 exp: 01/2011 2-Torque clamps to 80-100 in lb 3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.	0.00				m/	10	09	09 (1)
240 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo 8/10/09/13	0.00				(X)			

3-8T
120910

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/15 *[Signature]**mr*
10-9-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, August 13, 2010 1:00:20 PM

Page 1

Work Order ID: 61296



Parent Item: D407-667-105



Parent Item Name: Crosstube Fwd


Start Date: 8/16/2010

Required Date: 8/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM
 IPP Rev:G 08-05-16 chg QC6 to QC15 DD verified by:EC
 IPP Rev:H 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
 IPP Rev:I 08-07-14 add (scribe inside of tube) seq.6 DD verified by:EC
 IPP Rev:J 08-07-28 update as per (par 08-013) DD verified by:EC
 IPP Rev K 09.01.06 ECN 08-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A  Bolt		Purchased	No			250	Each	155.0000	10	10			

Location

Loc Qty

Loc Code

ST337

155

114752

55

115108

100

AN5-30A

Purchased

No

250

Each

110.0000

4

BOLT

Location

Loc Qty

Loc Code

ST339

110

102473

4

105144

10

112933

21

114437

25

114941

50

M114752 55
 M115108 100

M112933

W10/2/13 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 61296



Parent Item: D407-667-105



Parent Item Name: Crosstube Fwd

Start Date: 8/16/2010

Required Date: 8/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-32A

Purchased

No

250

Each

232.0000

4

4



Bolt



Lu

Location

Loc Qty

Loc Code

ST340

232

113121

4

114056

74

114405

50

115016

50

115108

50

15072

4

M114-56

~~AN9601D316~~

NAS1149D0563J

Purchased

No

250

Each

34.0000

18

18



Washer



M114742

Lu

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2873-043

Manufactured

No

230

Each

32.0000

2

2



Nut Plate Assembly



FI 10-09-10

Location

Loc Qty

Loc Code

LG

32

53966

10

56466

2

57337

20

x2

Friday, August 13, 2010 1:00:20 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Work Order ID: 61296



Parent Item: D407-667-105



Parent Item Name: Crosstube Fwd

Start Date: 8/16/2010

Required Date: 8/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2873-045

Manufactured No

230

Each

28.0000

2

2



Nut Plate Assembly



81 10-09-10

Location

Loc Qty

Loc Code

LG

28

53968

9

57336

19

x2

D2891-1

Manufactured No

230

Each

69.0000

2

2



2.25 Support



Location

Loc Qty

Loc Code

LG

69

46159

15

50952

18

53347

4

53773

20

55786

12

md 10-09-09

D3595-063-395

Manufactured No

230

Each

46.0000

4

4



RUBBER CUSHION



Location

Loc Qty

Loc Code

FP

10

44667

10

ST

36

60585

36

md 10 09 09

Friday, August 13, 2010 1:00:20 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61296



Parent Item: D407-667-105



Parent Item Name: Crosstube Fwd

Start Date: 8/16/2010

Required Date: 8/30/2010

Start Qty: 1.00

Required Qty: 1.00

D407-667-105TRN

Manufactured No

110

Each

2.0000

1

1



Crosstube Turning Detail



MB 10-08-30

Location

Loc Qty

Loc Code

LG

2

60254

1

60255

1

(X)

MS20601-AD4W10

Purchased

No

230

Each

172.0000

14

14



RT 10-09-10

RIVET

Location

Loc Qty

Loc Code

LG051

158

114245

58

115405

100

X 14

ST322

14

113220

14

MS21042L5

Purchased

No

250

Each

734.0000

4

4



10/13/13 (1)

Nut

Location

Loc Qty

Loc Code

ST139

234

114813

234

ST300

500

115156

500

m14813

Friday, August 13, 2010 1:00:20 PM

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Parent Item: D407-667-105



Parent Item Name: Crosstube Fwd

Start Date: 8/16/2010

Required Date: 8/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased: No

230

Each

103.0000

4

4



Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

103

112624

18

114687

35

114779

24

115057

26

ml 10.08.09

Friday, August 13, 2010 1:00:20 PM

Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

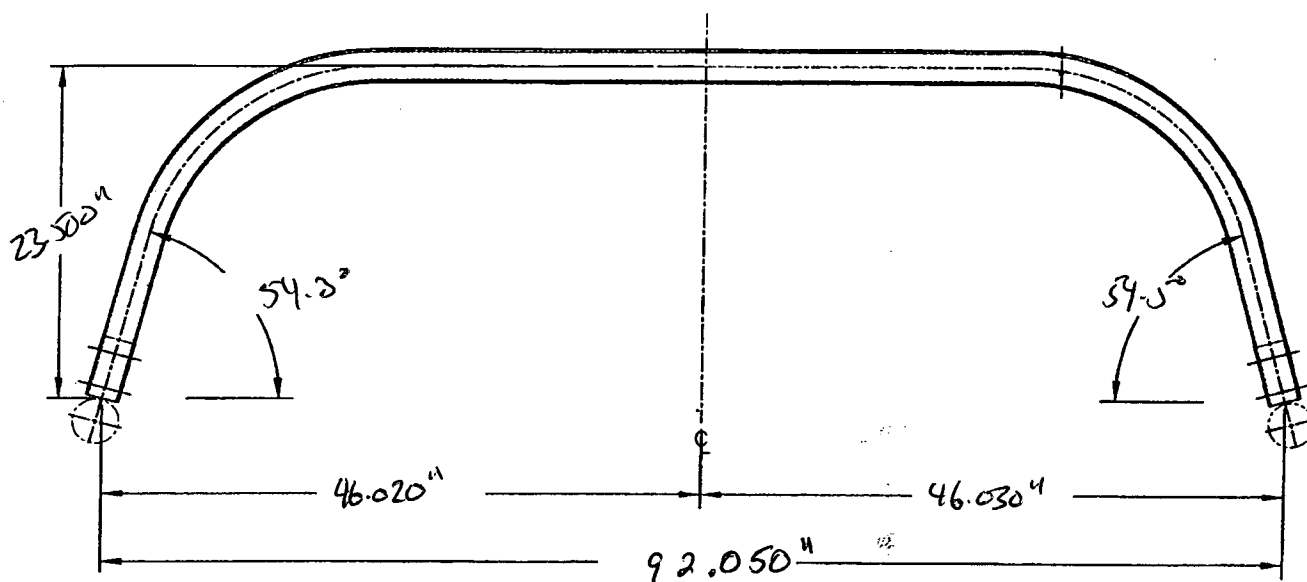
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DART AEROSPACE LTD		Work Order: 61296
Description: Crosstube High Fwd (407)		Part Number: D407-667-105
Inspection Dwg: D407-667-145 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.41	23.67
1/2 Span	45.81	46.07
Angle	54	56
Total Span	91.63	92.13



Comments

QC15 Inspection	S
Date	10/06/30

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.12	Dimensions updated per Dwg Rev C	KJ	

Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

01296

RELEASED
03/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D407-667-145	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

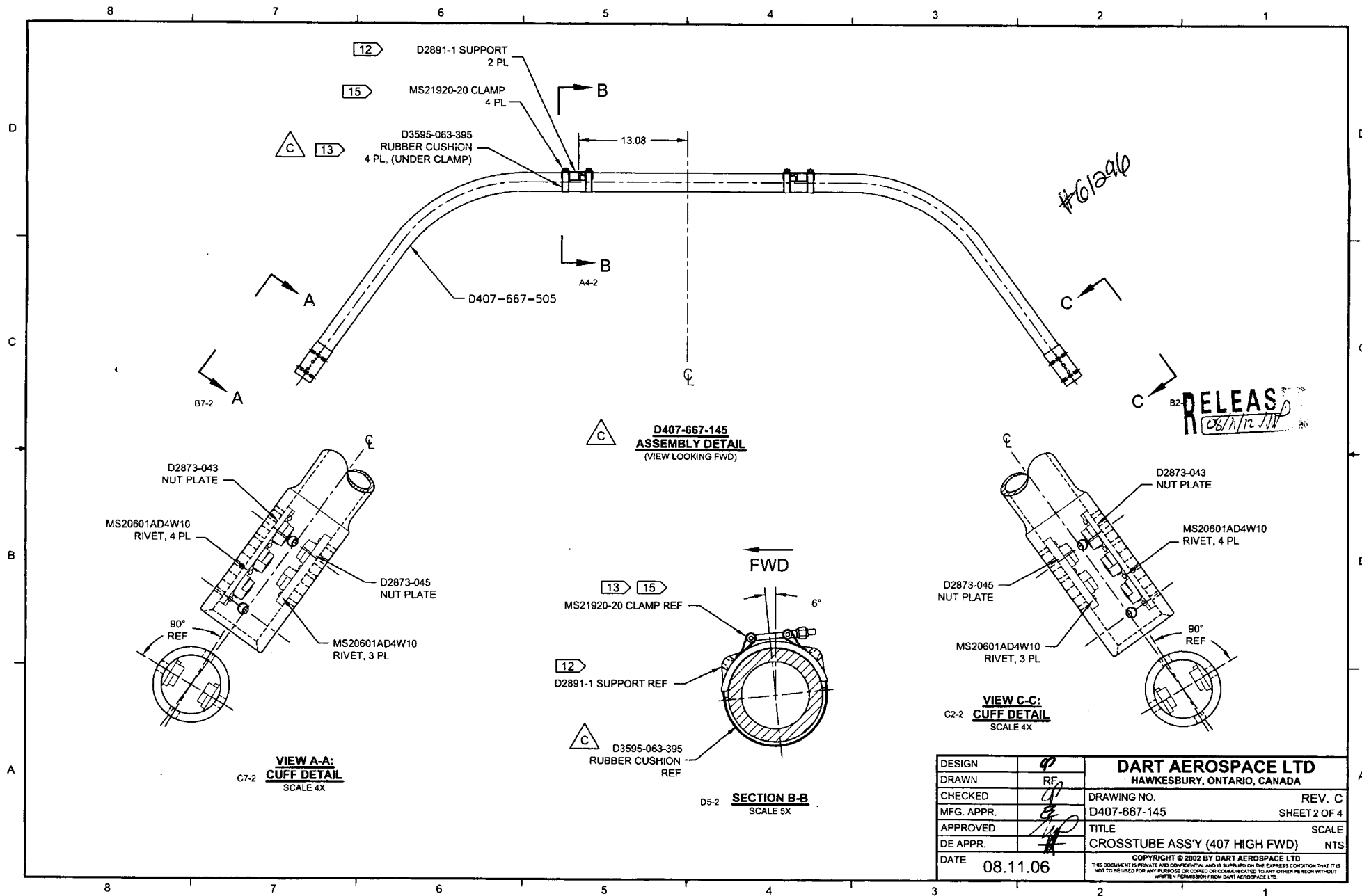
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DP	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EP	DRAWING NO.	REV. C
MFG. APPR.	EP	D407-667-145	SHEET 2 OF 4
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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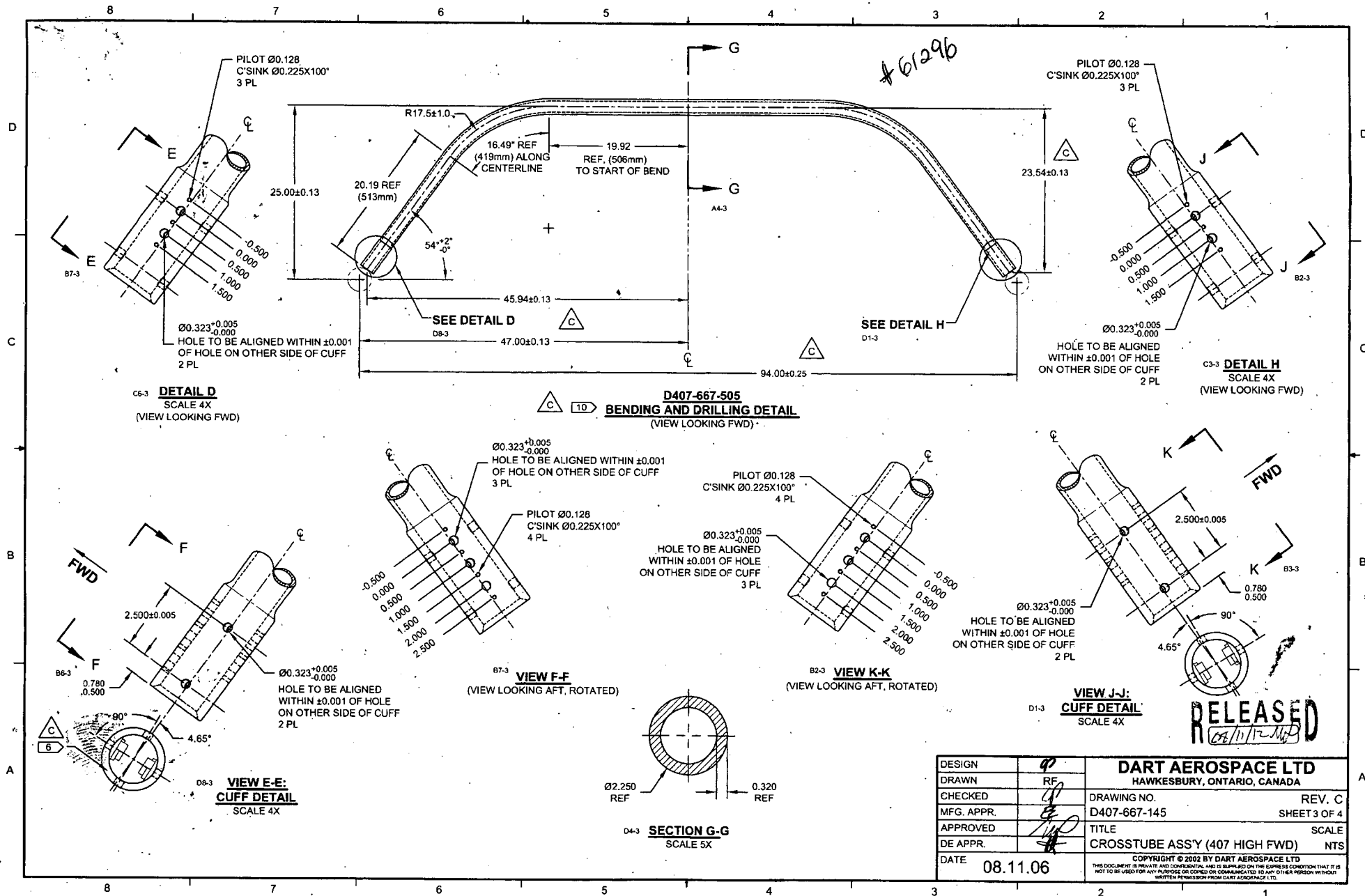
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	47	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. C
MFG. APPR.	47	D407-667-145	SHEET 3 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

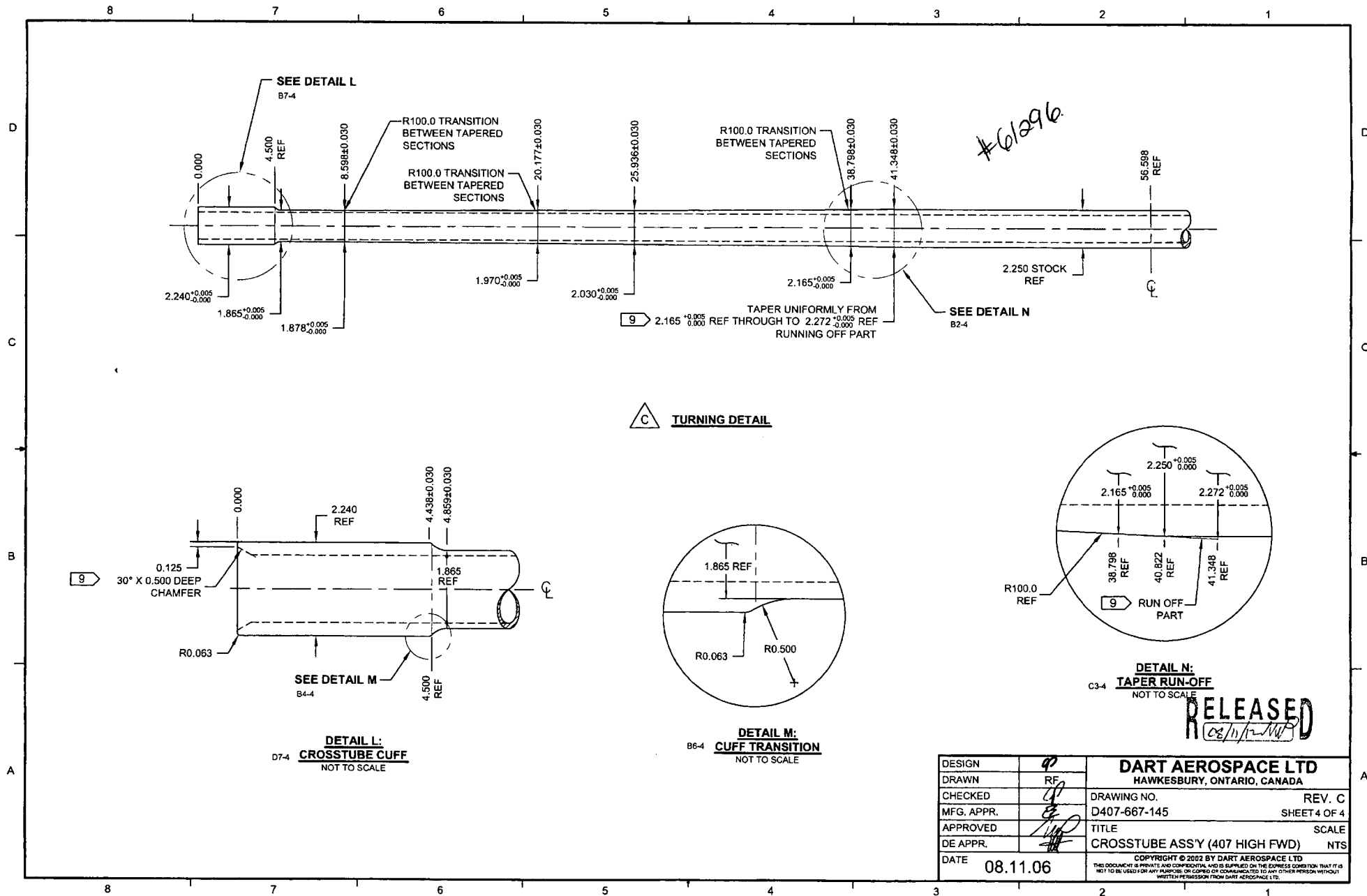
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15188

CLIENT	DART AEROSPACE	DATE	SEP 2 2010	PAGE	1	OF	1
ATTENTION	LINDA / CHANTAL	ACUREN JOB NO.	188-10-0832	TIME	AM	<input checked="" type="checkbox"/>	PM
ADDRESS	1270 ABERDEEN STREET. HAWKESBURY ON. VIC 317	PO/VO NO.	12506	WORK LOCATION	HAWKESBURY PLANT.		
PROJECT	F.P.I. ON CROSS TUBES.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007		
ITEM(S) EXAMINED	4 PCS. + 5 MACHINED STUDS						

JOB DESCRIPTION	PROCEDURE NO. LT 6002	REV./DATE	TECHNIQUE NO. LT 1042	REV./DATE	2008		
PART NO.			MATERIAL	ALUMINUM THICKNESS VARIOUS			
SCOPE	WET FLUORESCENT LIQUID - STAINLESS STEEL PENETRANT. INSPECTION CARRIED OUT 100% EXTERNAL						

TEST DETAILS		
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNA FLUX	BLACK LIGHT S/N 16459 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT	2LG7 MINIMUM DWELL TIME 45 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H2O MINIMUM DRY TIME > 10 MIN.	OTHER LABINO
DEVELOPER	WD 52 MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N 1098866 CAL DUE DATE OCT-19 2010
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F <input type="checkbox"/> -4°C/20°F TO 10°C/50°F <input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F

RESULTS-	<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
----------	---

1 - CROSS TUBE - W.O. 61294 ✓
1 - CROSS TUBE - W.O. 61295 ✓
1 - CROSS TUBE - W.O. 61296 ✓
1 - CROSS TUBE - W.O. 61297 ✓
5 - STUDS - W.O. 61371 ✓

M 10-09-08

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES			
CLIENT REPRESENTATIVE	Matt Murphy	DTR #	E 27427
TECHNICIAN (SIGNATURE):	Mike Johnston	REPORT REVIEWED BY:	
NAME (PRINT):	1 ST TECHNICIAN	NAME	INITIALS
CGSB LEVEL	SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No		CGSB REG. No	